

Work Order ID 125797

125797

Page 1

Wednesday, October 22, 2014 12:35:29 PM

Item ID: D4353-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw Assembly
 Start Date: 10/21/14 Start Qty: ***2*** Cust Item ID:
 Required Date: 10/21/14 Req'd Qty: ***2*** Customer:
 Reference:
 Approvals: Process Plan: MLJ Date: 14-10-22 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4353	B								

120

0.00

120

Waterjet

FLOW CNC Waterjet

punch.

FLOW WATER JET

Memo

Cut Blank as per D4353-1 File

**PI cut as per drawing.
D4353-041 REV.B*

P/O: 26351

** C214/11/03 **

130

0.00

130

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Inspect material for defects or damage prior to machining

2-Machine as per FolioFB050 and Dwg

FOLIO REV: B

DWG REV: B

3-Deburr

6 8

DAS

20

9-89

DAS

44

9-89

15-03-09

15/03/10

rec'd

*rec'd + inspect
attached cufc to w/o*

OK SP14-11-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube ☐</td> <td style="width:25%;">Crosstube ☐</td> <td style="width:25%;">Water Jet ☐</td> <td style="width:25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

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Wednesday, October 22, 2014 12:35:29 PM

Item ID: D4353-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw Assembly

Start Date: 10/21/14 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 10/21/14 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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153

0.00

153

0.00

Small Fab

Memo

Small Fab

PRESS D4353-3 INSERT INTO BEARPAW

154

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

154

0.00

QC

Memo

Quality Control

155

Identify as per dwg & Stock Location:_____

0.00

155

0.00

Packaging

Memo

Packaging

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order ID 125797***125797***

Page 4

Wednesday, October 22, 2014 12:35:29 PM

Item ID: D4353-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw Assembly

Start Date: 10/21/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/21/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

ML5 15-03-16
mf
15-3-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Page 1

Wednesday, October 22, 2014 12:35:29 PM

Work Order ID: 125797

125797

Parent Item: D4353-041

D4353-041

Parent Item Name: Bearpaw Assembly

Start Date: 10/21/14

Required Date: 10/21/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-04-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	721.4000		15 26 39			
MUHMWB10									**			CL14/11/03	
UHMW 1" Black - 48"x120" Tivar Mfg.#52480104													

Location Loc Qty Loc Code

MAT014 321.4

m128267 41

m128668 255.3

m129293 25.1

TPI 400

m130421 400

Each 4.0000

D4353-3

Manufactured No

D4353-3

Bearpaw Insert

FF

MAR 11 2015

Location Loc Qty Loc Code

ST085 125851 1

70727 1

ST100 3

121182 1

124862 2

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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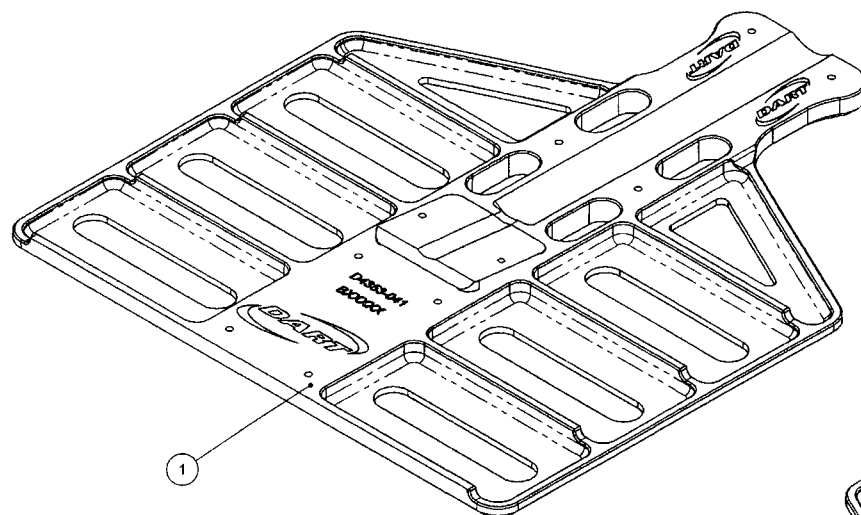
DART AEROSPACE LTD		Work Order: 125797
Description: Bearpaw		Part Number: D4353-1
Inspection Dwg: D4353	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

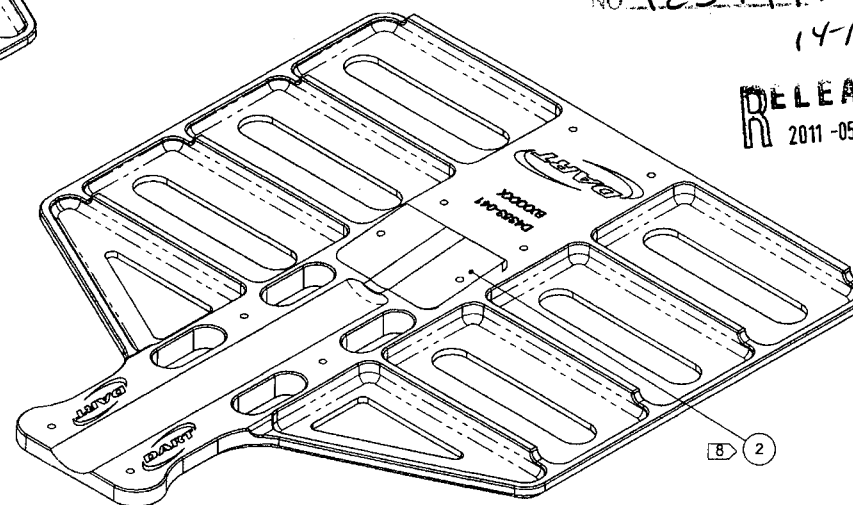
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/-0.030	.377	✓		SLO8	Vern
7.375	+/-0.010	7.380	✓		CNC02	12" Vern
12.50	+/-0.030	12.500	✓		SLO1	Tape
1.38	+/-0.030	1.380	✓		SLO8	
3.813	+/-0.010	3.813	✓		"	
24.00	+/-0.030	24.00	✓		SLO1	
10.09	+/-0.030	10.100	✓		CNC02	
1.00	+/-0.030	.996	✓		SLO8	
6.150	+/-0.010	6.152	✓		CNC02	
3.038	+/-0.010	3.040	✓		"	
6.563	+/-0.010	6.565	✓		"	
9.250	+/-0.010	9.250	✓		"	
27.00	+/-0.030	27.000	✓		SLO1	
1.25	+/-0.030	1.250	✓		SLO8	
0.30 x 45°	+/-0.030	.300 x 45°	✓		"	
1.38	+/-0.030	1.375	✓		"	
0.63	+/-0.030	.620	✓		"	
0.95	+/-0.030	.940	✓		"	
R0.25	+/-0.030	.250	✓		Rad gauge	
0.70	+/-0.030	.700	✓		SL11	Depth gauge
0.07 x 45°	+/-0.030	.072	✓		SLO8	
Ø0.650	+/-0.010	.651	✓		SLO8	
Ø0.261	+0.006/-0.001	.260	✓		SLO8	
0.400	+/-0.010	.400	✓		SL11	
4.750	+0.012/-0.000	4.750	✓		SLO8	
4.000	+0.012/-0.000	4.000	✓		"	
5.75	+/-0.030	5.750	✓		"	
0.63	+/-0.030	.620	✓		"	
0.57	+/-0.030	.565	✓		SLO8	
0.25	+/-0.030	.242	✓		SLO8	
0.45	+/-0.030	.450	✓		SL11	
0.06 x 45°	+/-0.030	.060 x 45°	✓		SLO8	
R0.25	DAS +/-0.030	.250	DAS		Rad gauge	

Measured by: 20 9-89	Audited by: 14 9-89	Preliminary Approval:
Date: 15-03-09	Date: 15/03/11	Date:
Rev	Date	Change
A	11.07.26	New Issue
P/O D4353-041		
Revised by	Approved	
KJ		

ITEM	QTY	P/N	DESCRIPTION
	X	D4353-041	429 BEARPAW ASSEMBLY
1	1	D4353-1	429 BEARPAW
2	1	D4353-3	429 BEARPAW INSERT



D4353-041 429 BEARPAW ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125797 MJS
14-10-22

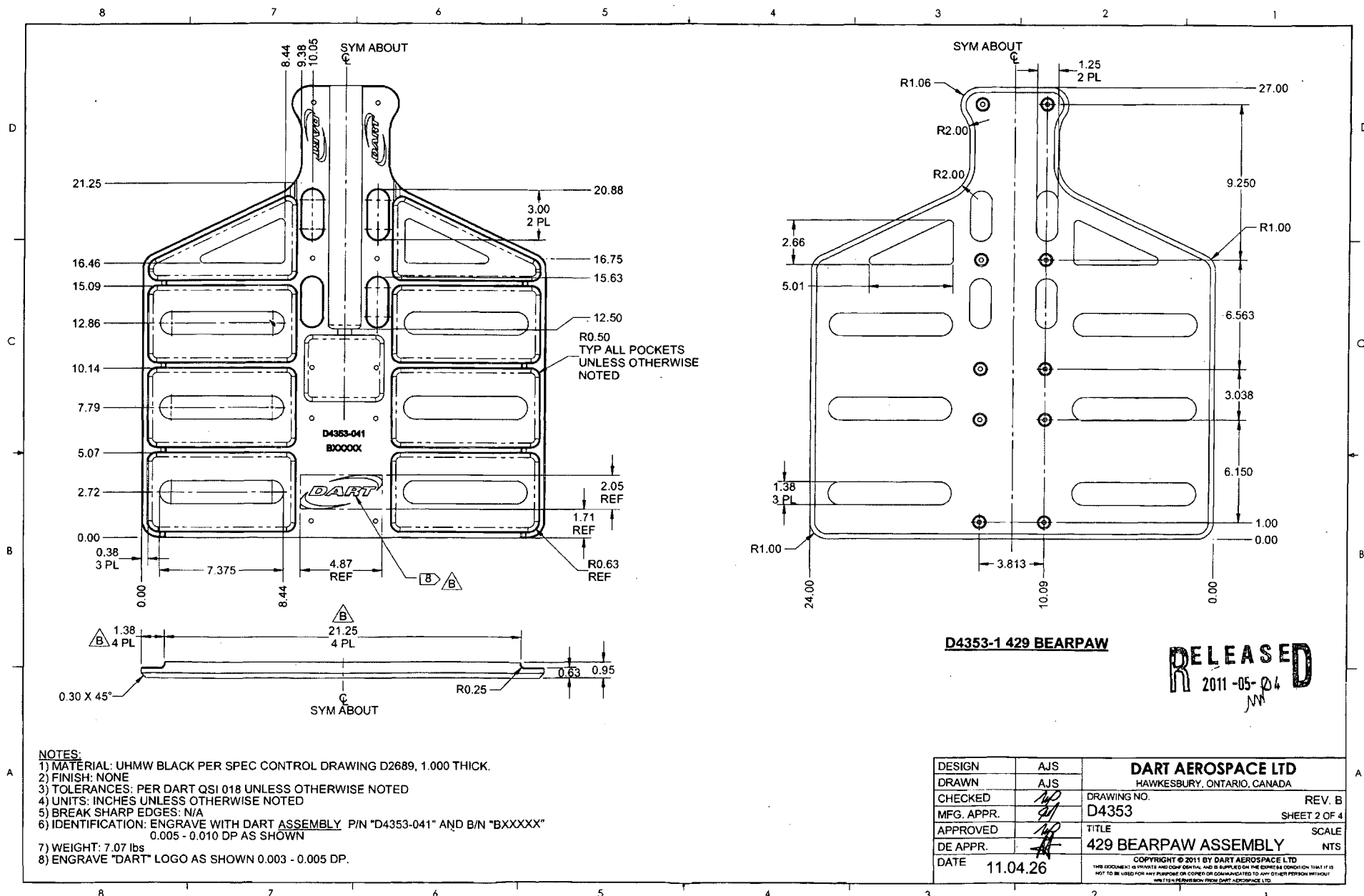
RELEASED
2011-05-24
NM

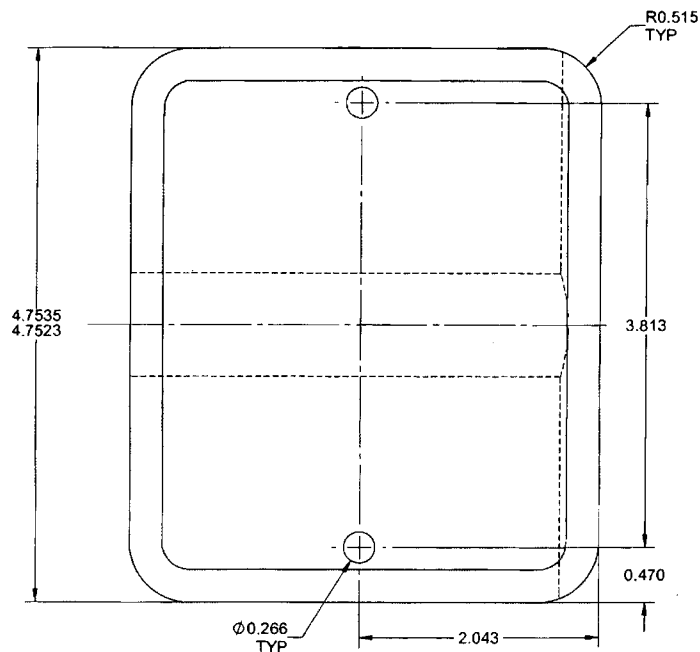
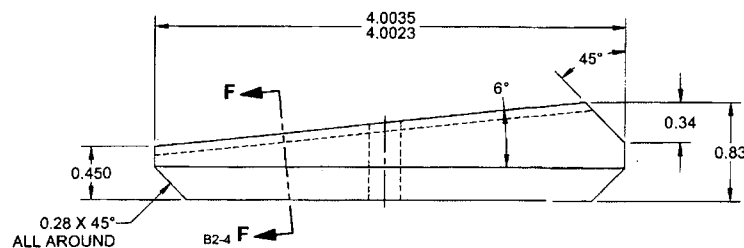
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.45 lbs
- 8) PRESS FIT

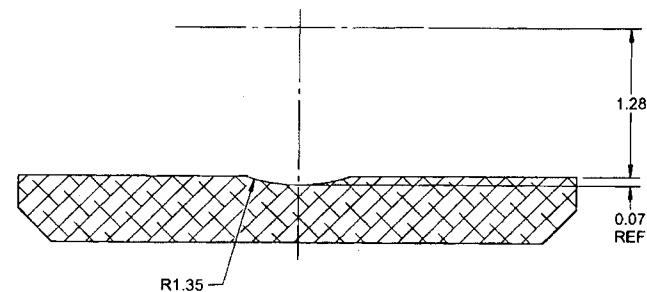
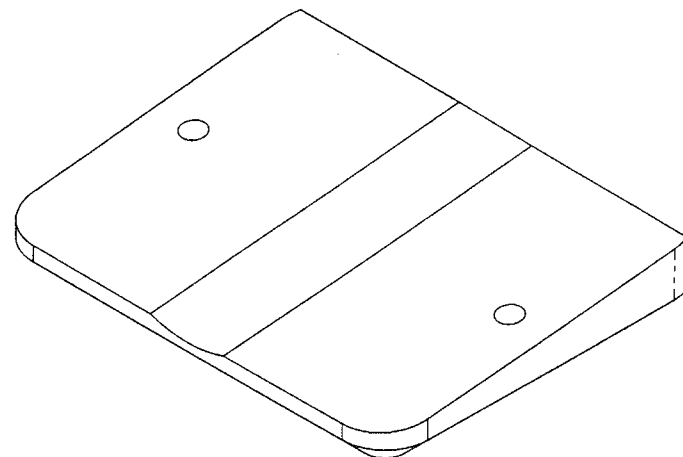


B	SHT 1 WEIGHT CORRECTED WAS 8.24 lbs. SHTS 1-3 DART LOGOS UPDATED. SHT 2, ZONE BB, AFT POCKET REDUCED. RIB INCREASED IN HEIGHT. SHT 3 SECTS. B.C & D. RIB INCREASED IN HEIGHT.	AJS	11.04.26
A	NEW ISSUE	AJS	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	





D4353-3 429 BEARPAW INSERT



SECTION F-F C7-4

RELEASED
2011-05-24

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.38 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26351**

Purchase Order Date 11/3/2014

PO Print Date 11/5/2014

Page Number 1 of 3

Order From :

VC-TPI001

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED QTY

Contact Name

Vendor Phone 450-633-0484

Ship To Contact

Ship To Phone

Ship Via: TST Overland

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	125452	D2995 BEARPAWS	11/10/2014 Yes 11/10/2014		6.00	\$29.22	\$175.32
	CUT AS DWG D2995 REV. A						
						Line Total:	\$175.32
2	125797	D4353-041 BEARPAWS	11/10/2014 Yes 11/10/2014		6.00 ✓	\$43.28	\$259.68
	CUT AS PER DWG D4353-041 REV. B						
						Line Total:	\$259.68
3	125851	D4353-3 BEARPAWS	11/10/2014 Yes 11/10/2014		6.00	\$6.50	\$39.00
	CUT AS PER DWG D4353-3 REV.B						

Note:

11/5/2014

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6399
Date: 2014-11-06
Page: 1

Sold to: Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Ship to: Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 100812	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-11-06
Tracking No.:	

Item No.	Unit	Description	Quantity
d2995	Chaque	d2995.bearpaw	6
d4353-041	Chaque	d4353-041 bearpaw ✓	6
d5022-1p	Chaque	d5022-1p foam, side panel, fwd	12
d5022-3p	Chaque	d5022-3p foam, side panel, aft	4
d5022-5p	Chaque	d5022-5p foam, side panel, aft	4
d4353-3	Chaque	d4353-3 bearpaw	6
PO 26351			

SP/14-11-10

Comment: Des frais d'intérêts de 2% / mois seront chargés sur tout compte passé du après 30 jours